

Work Order ID 86132

June-21-12 8:25:02 AM

86132

Page 1

Item ID: D3774-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Seat Back, LH/RH

Start Date: 21/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/21

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3774	Rev B								
100		0.00							
100	HAND FINISHING THERMOFORMING								
Thermoform	Memo	0.00				x4			Wh 12/06/25
Thermoforming Machine	Set up machine program D3774-3Set up clamping frame as per folio								
110		0.00							
110	HAND FINISHING THERMOFORMING								
Thermoform	Memo	0.00				x4			Wh 12/06/25
Thermoforming Machine	Cut Blanks								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

86132

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Customer:

Start Date: 21/06/2012 **Start Qty:** 4.00 ***4***

Required Date: 05/07/2012 Req'd Qty: 4.00 * / *

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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NOTE: Date & initial all entries

86132

Page 4

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Seat Back, LH/RH

Start Date: 21/06/2012 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 05/07/2012 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID

Tool #Plan
Code

Accept
Qty

Reject Qty

Reject
Number

**Insp.
Stamp**

170

Identify as per dwg & Stock Location: SF-257 0.00

0.00

170

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

OK 12/7/6

mf
12-07-05

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

June-21-12 8:25:05 AM

Page 1

Work Order ID: 86132

86132

Parent Item: D3774-3

D3774-3

Parent Item Name: Seat Back, LH/RH

Start Date: 21/06/2012

Required Date: 05/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP REV:A New Issue 08.06.04 DL verified by:DD

IPP REV. B Dwg. Update 08.08.19 DL

Ipp Rev. C

Add Step 115 Dry Material 10/04/21 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	1,739.446	10.667	42.668			

MI FXS 125-F60029-04

GE PLASTICS LEXAN SHEET

**

Location

Loc Qty

Loc Code

MAT018

1503

121803

1503

MAT019

236.4464

119937

236.4464

42.67sg ft

DL
12/06/25

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	86132
Description: Seat Back		Part Number:	D3774-3
Inspection Dwg: D3774	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:	OK	Date:	12/06/25
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3	+/-0.100	1.37"	✓			
33.9	+/-0.100	33.8"	✓			
0.085	Min	0.112"	✓			
0.100	Min	0.106"	✓			
0.100	Min	0.101"	✓			
0.100	Min	0.105"	✓			
0.100	Min	0.114"	✓			
0.100	Min	0.106"	✓			
0.100	Min	0.106"	✓			
0.100	Min	0.104"	✓			
0.100 0.065"	Min	0.074"	✓			

Measured by:	OK	Date:	12/06/27
Audited by:		Date:	
Prototype Approval:	N/A	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DL	
B	09.05.19	Dimension 17.4 removed	KJ	MA

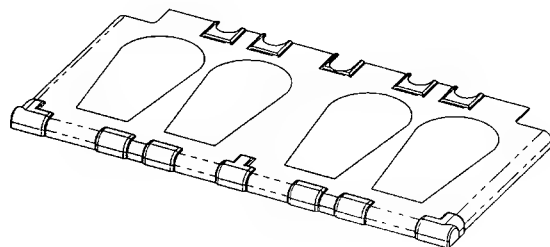
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

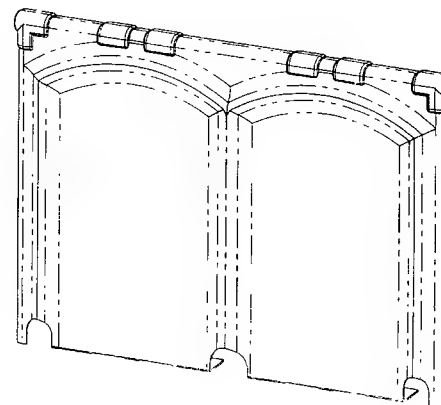
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3774-1 SEAT BOTTOM



D3774-3 SEAT BACK

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86132 *MLT*

12/06/21

RELEASED
08-11-11

B	UPDATE CUTOUT DIMENSIONS (ZN D4-2, D6-2, C4-3, C7-3). UPDATE MINIMUM THICKNESS (ZN A5-2, A5-3). ADD HOLES ON D3774-3 (ZN B6-3). REASON: MANUFACTURING CAPABILITIES	PH	08.07.25
A	NEW ISSUE	HS	08.06.23
REV.	DESCRIPTION	BY	DATE
DESIGN	HSJ	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO D3774 REV. B SHEET 1 OF 3 TITLE SEAT SCALE NTS <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	
DRAWN	<i>PH</i>		
CHECKED	<i>PH</i>		
MFG. APPR	<i>PH</i>		
APPROVED	<i>PH</i>		
DE APPR.	<i>PH</i>		
DATE	08.07.25		

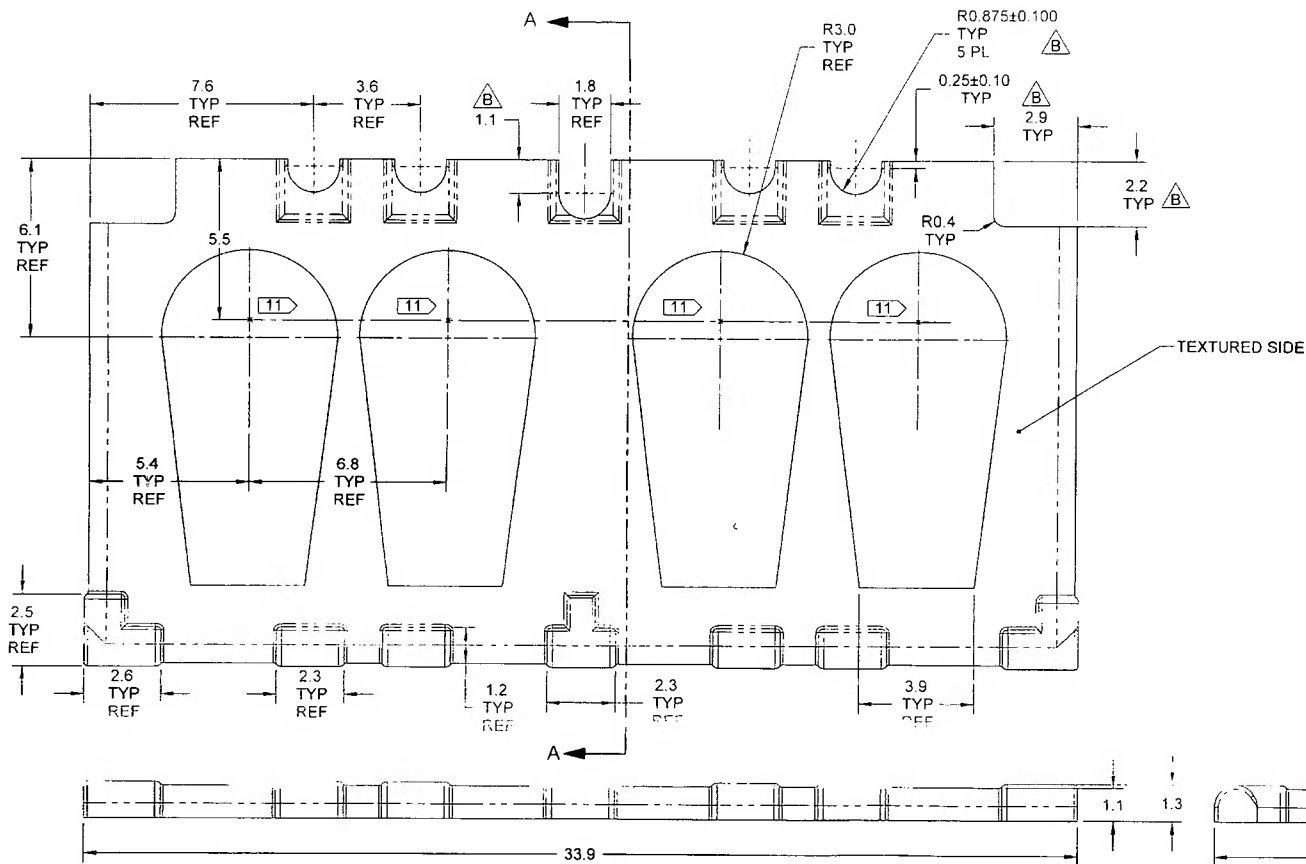
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION A-A

D3774-1 SEAT BOTTOM

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-1" USING VIBRATING STYLUS
- 7) WEIGHT: 2.93 lbs
- 8) PART TO BE PRODUCED FROM MOLD DT9022 AND PER DART QSI 022
- 9) OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9022
- 10) MINIMUM MATERIAL THICKNESS AFTER FORMING ON FLANGES (WITHIN 2.0 FROM EDGES) IS 0.085
- 11) MINIMUM MATERIAL THICKNESS AFTER FORMING AT THESE POINTS IS 0.100

RELEASED
08-08-11/14

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	AM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	5	DRAWING NO.	REV. B
MFG. APPR.	1/10	D3774	SHEET 2 OF 3
APPROVED	1/10	TITLE	SCALE
DE APPR.	1/10	SEAT	NTS
DATE	08.07.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
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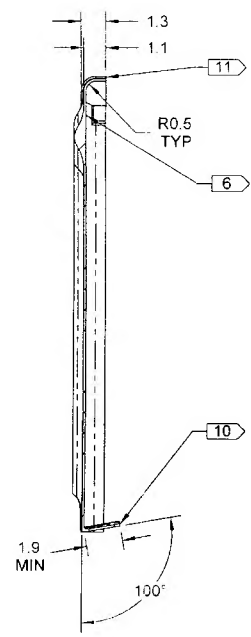
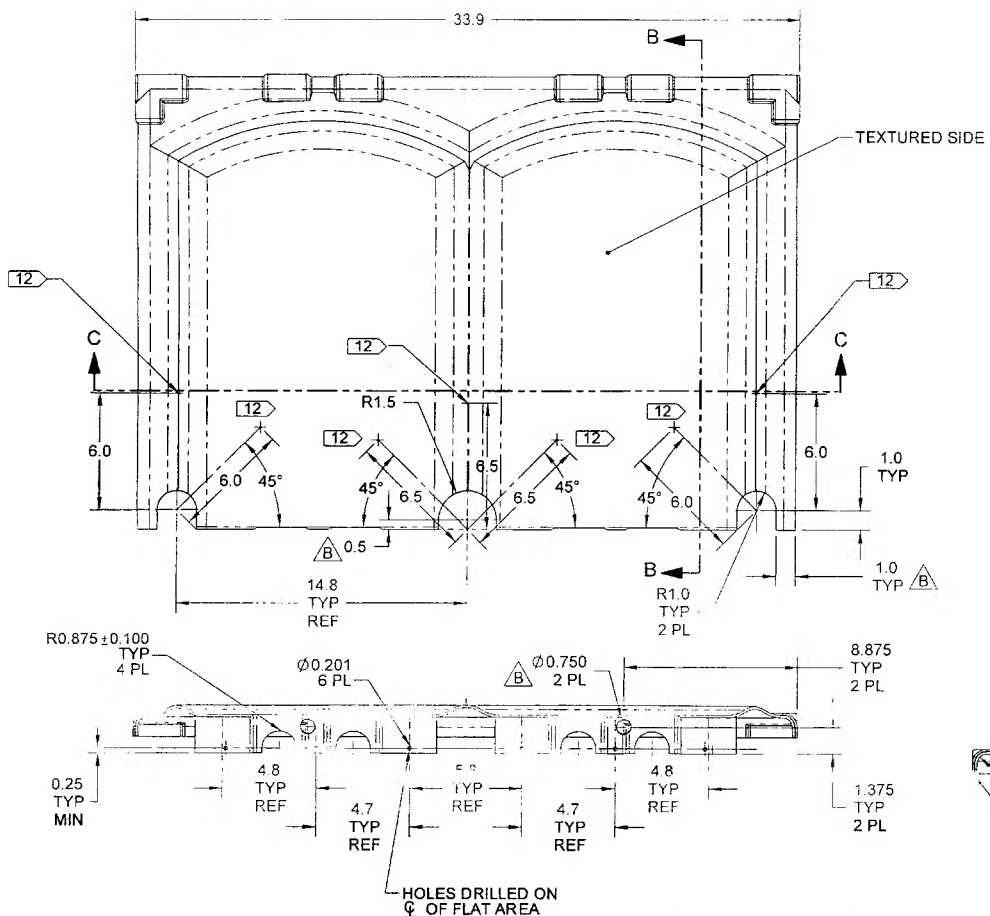
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

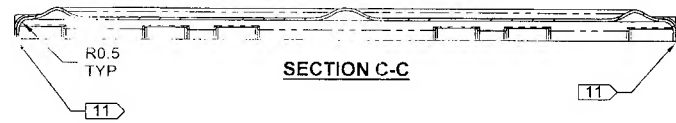
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



SECTION B-B



SECTION C-C

D3774-3 SEAT BACK

RELEASED
08-07-11

- NOTES:**
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS.125-F60029-04)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-3" USING VIBRATING STYLUS
 - 7) WEIGHT: 4.82 lbs
 - 8) PART TO BE PRODUCED FROM MOLD DT9023 AND PER DART QSI 022
 - 9) OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9023
 - 10) MINIMUM MATERIAL THICKNESS AFTER FORMING ON BOTTOM FLANGE IS 0.085
 - 11) MINIMUM MATERIAL THICKNESS AFTER FORMING FLANGES (WITHIN 2.0 FROM EDGES) IS 0.085
 - 12) MINIMUM MATERIAL THICKNESS AFTER FORMING AT THESE POINTS IS 0.100

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AD		
CHECKED	JS	DRAWING NO.	REV. B
MFG. APPR.	WJ	D3774	SHEET 3 OF 3
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	SEAT	NTS
DATE	08.07.25	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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